

Work Order ID 66611 -2

Tuesday, February 22, 2011 3:12:04 PM

Page 1

Item ID: D3315-5

Revision ID:

Item Name: Wearplate

Start Date: 2/22/2011

Required Date: 2/25/2011

Reference:

Approvals:

Process Plan: *mf*

QC:

Date: 11-02-22

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3315

Rev B

0.00

11-02-22

100



Waterjet

FLOW WATER JET

0.00

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3315

10 10 - 003

Dwg Rev: 13

Prog Rev: 13

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

11-02-22

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

6 0



Setup Start

Stop

Cust Item ID:

Customer:



6

mf 11/02/22

Work Order ID 66611

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Page 2

Item ID: D3315-5

Accept

Revision ID:

Item Name: Wearplate

Start Date: 2/22/2011 Start Qty: 5.00

Required Date: 2/25/2011 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

1- Form using DT8751 Die as per Dwg D3315Rev: B
2- Form using DT8179 Die as per Dwg D3315Rev: B

11/02/23

(5)

140



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

8/02/23

(X5)

150



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Weld hard surface using D3315-5T3 as per QSI 004 and Dwg D3315 Rev: B
Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod M16678

EL 11-3-1

(X5)

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Page 3

Item ID: D3315-5

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 2/22/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



8 ulozlo

QC

Memo

0.00

Quality Control

KJ

-5

170

QC5- Inspect part completeness to step on W/O

0.00



8 ulozlo

QC

Memo

0.00

Quality Control

Ⓢ

180

Grey Sandtex(Ref:4.3,5,6) per QSI005 4.3

0.00



M115128

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45
320 OF
11:15

Ⓢ M-L 11/03/02

Work Order ID 66611

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Page 4

Item ID: D3315-5

Revision ID:

Item Name: Wearplate

Start Date: 2/22/2011 Start Qty: 5.00

Required Date: 2/25/2011 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

5 6 44 11/03/07

200



Packaging

Packaging

Packaging

Memo

0.00

0.00

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-5, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 9976A

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/2 54 32

11/03/04 44

11/03-02

Picklist Print

Tuesday, February 22, 2011 3:12:01 PM

Page 1

Work Order ID: 66611



Parent Item: D3315-5



Parent Item Name: Wearplate

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: A 05.05.12 New issue KJ/JLM
IPP Rev:B As per Rev B 06-03-24 JLM
IPP Rev:C Now on Waterjet 07-07-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

100

sf

93.1250

1.8345

9.655263

12

18 11-2-22



1010/1025 sheet 16GA

Location

Loc Qty

Loc Code

MAT

81

116791

81

MAT19

12.125

111410

12.125

111410

DART AEROSPACE LTD		Work Order: 00611	
Description: Wearplate		Part Number: D3315-5	
Inspection Dwg: D3315 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.31	+/-0.030	34.31	x		11-gage	
30.215	+/-0.010	30.215	x			
24.215	+/-0.010	24.215	x			
21.611	+/-0.010	21.611	x			
17.965	+/-0.010	17.965	x			
16.026	+/-0.010	16.026	x			
14.735	+/-0.010	14.735	x			
12.815	+/-0.010	12.815	x			
6.465	+/-0.010	6.465	x			
5.464	+/-0.010	5.471	x			
4.527	+/-0.010	4.528	x			
3.550	+/-0.010	3.557	x			
5.214	+/-0.010	5.209	x			
Ø0.300	+0.006/-0.001	0.304	x		✓	
Ø0.266 x 0.575	+/-0.010	0.267 x 0.577	x		✓	
Ø0.266 x 0.450	+/-0.010	0.268 x 0.451	x		✓	

Measured by: IB
Date: 11-2-22

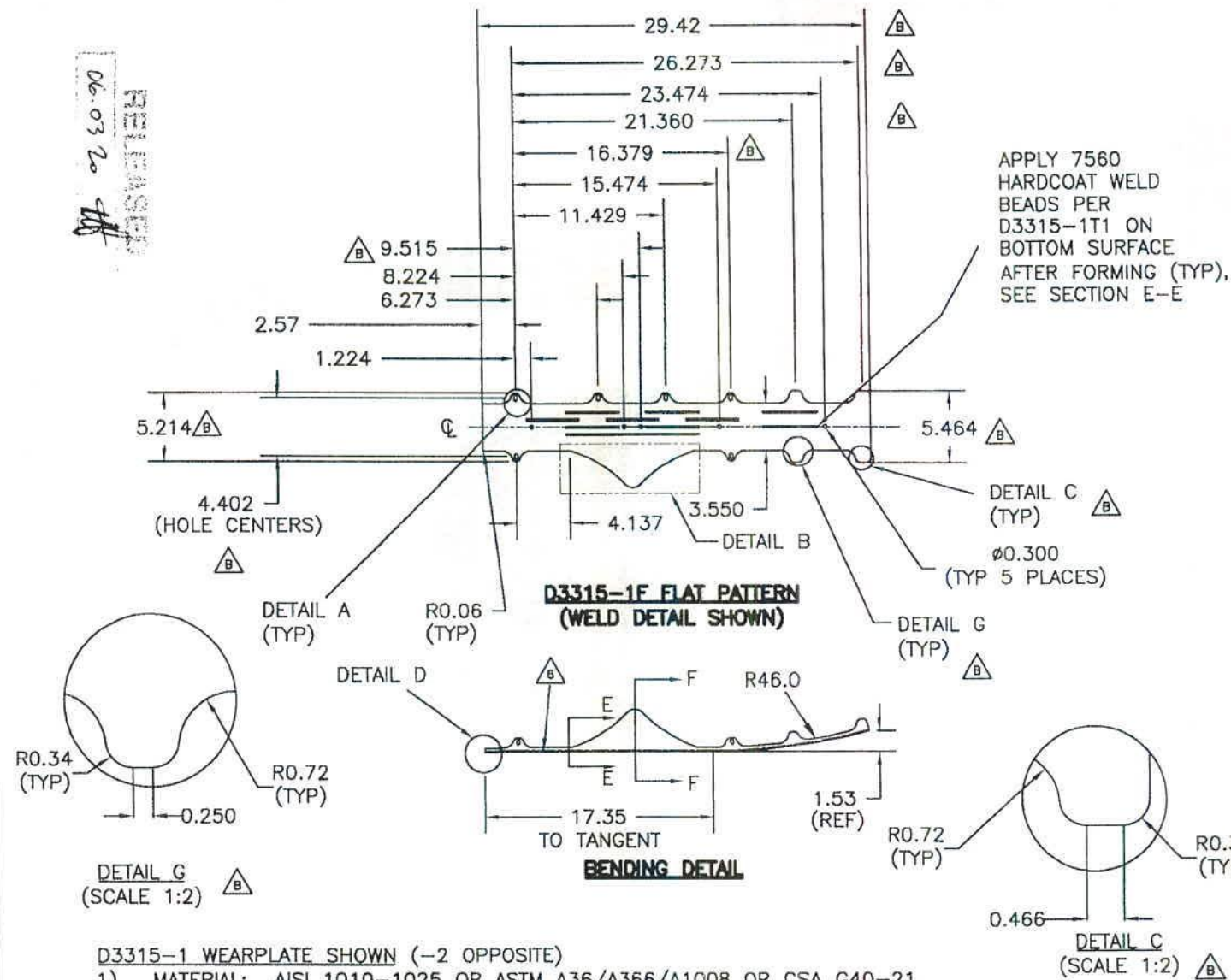
Audited by: [Signature]
Date: 11/02/22

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.22	New Issue	KJ/EC/DD [Signature]	[Signature]



DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	WEARPLATE	REV. B
		DRAWING NO.	D3315	SHEET 1 OF 4
		SCALE	1:12	
A	04.09.10	NEW ISSUE		
B	06.01.31	UPDATE DIMENSIONS		

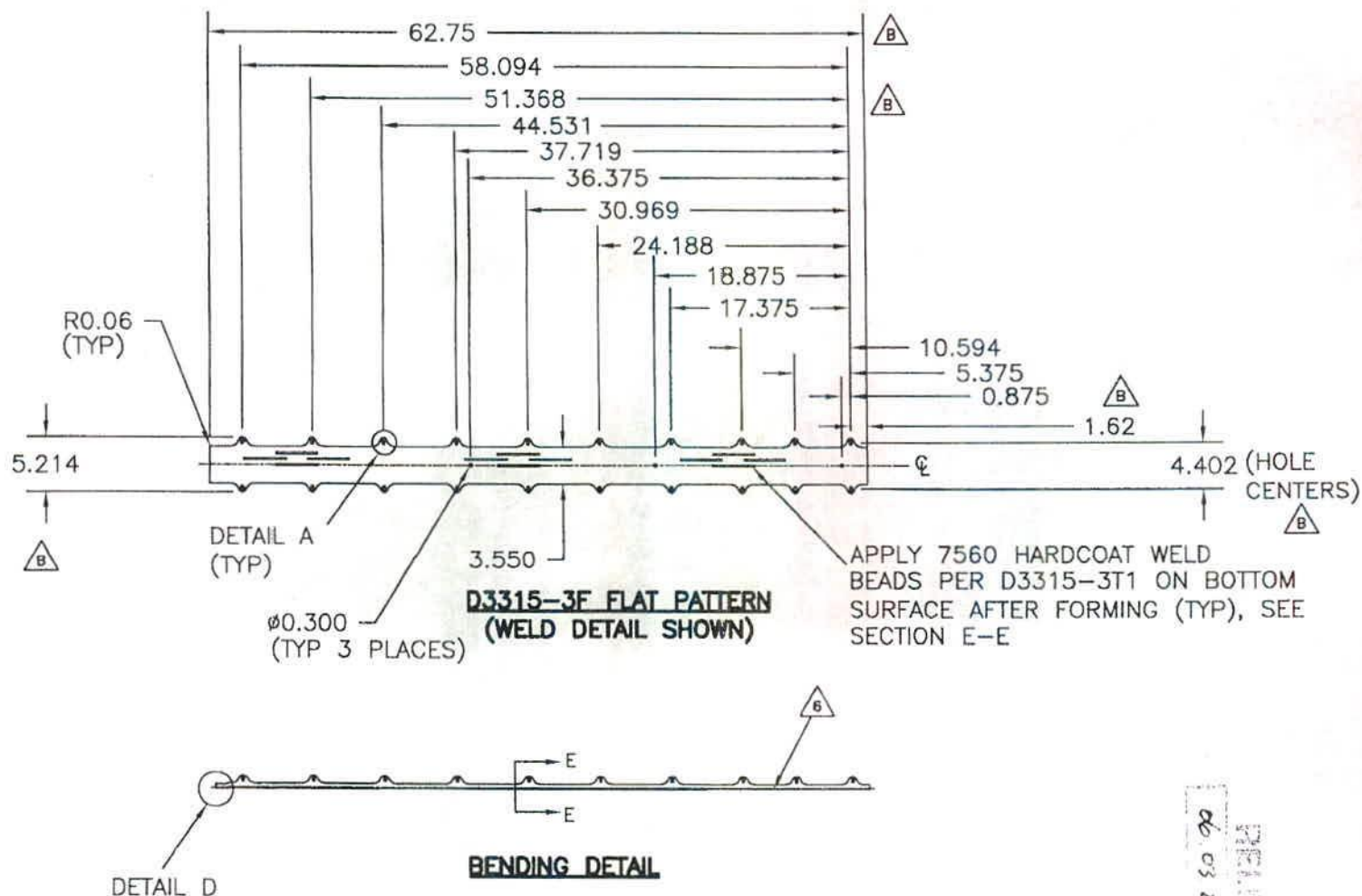


- D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)**
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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06.03.20
RELEASED

DART

**D3315-3F FLAT PATTERN
(WELD DETAIL SHOWN)**

BENDING DETAIL

D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)

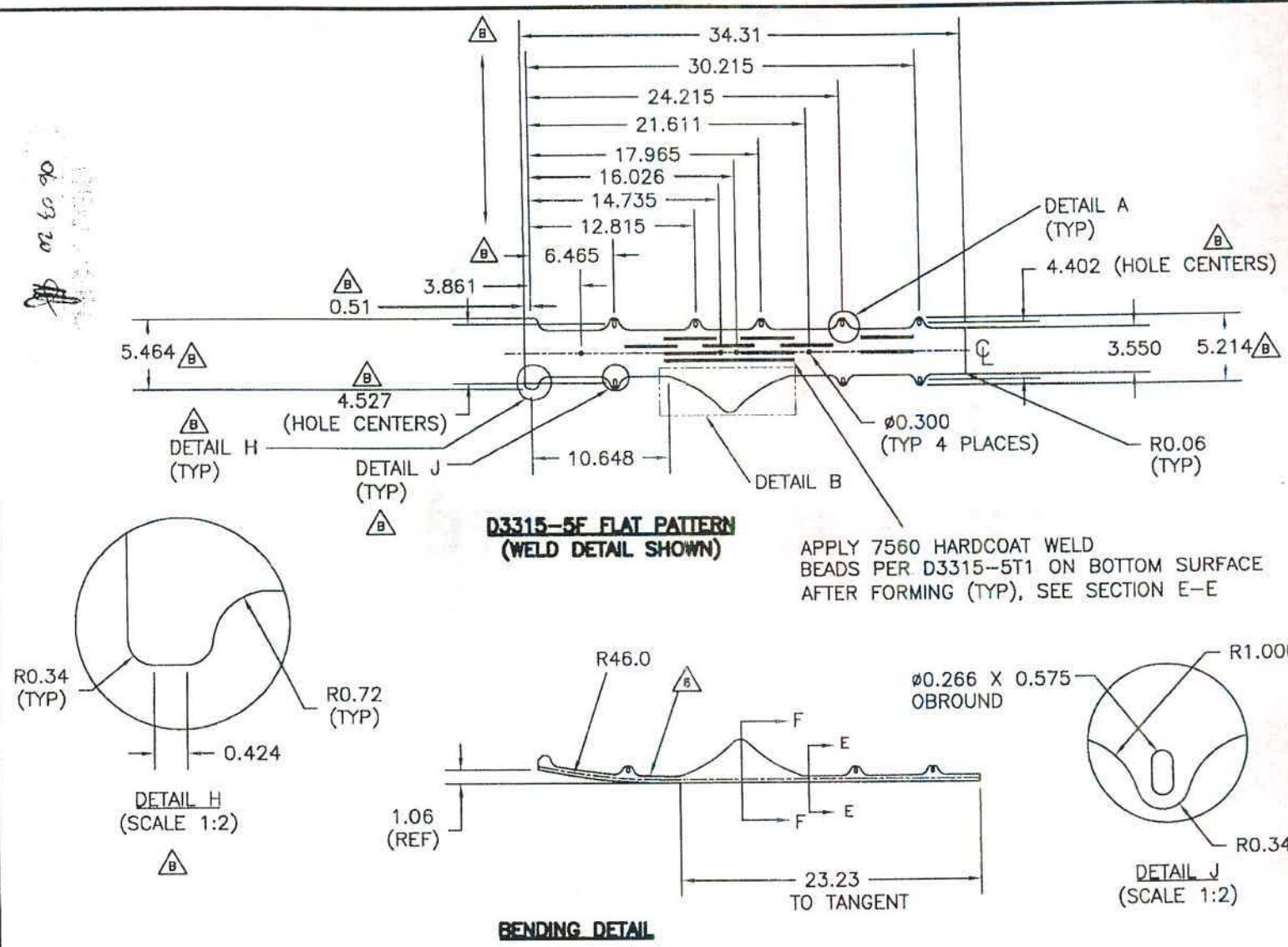
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- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 2 OF 4
				SCALE 1:16

26 03 20 *[Signature]*



DESIGN	014	DRAWN BY	014	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	DRAWING NO.	D3315	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 4
				SCALE 1:12



- D3315-5 WEARPLATE SHOWN (-6 OPPOSITE)**
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
 - 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
 - 3) WELD PER DART QSI 004
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSION ARE IN INCHES
 - 6) IDENTIFY ON INSIDE SURFACE AS INDICATED
- "TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

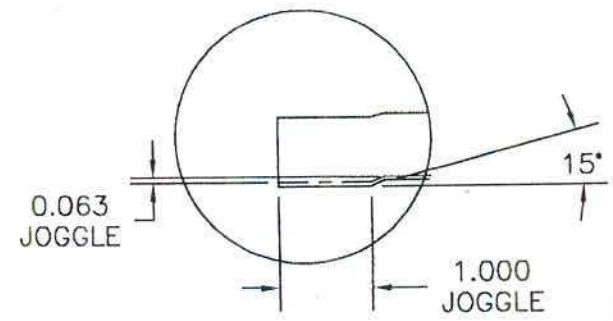
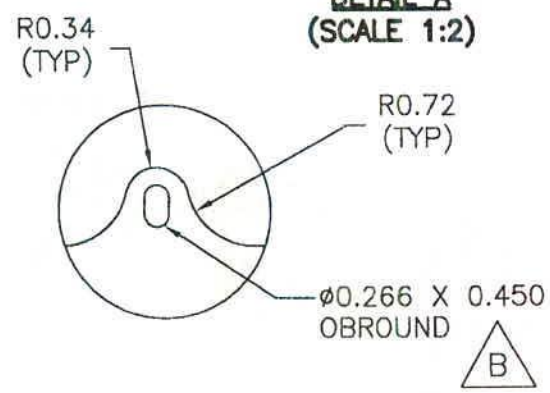
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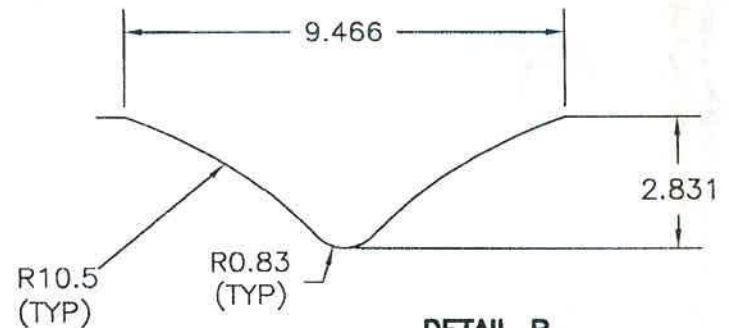


DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED		APPROVED		DRAWING NO. D3315	SHEET 4 OF 4
DATE	06.01.31	TITLE	WEARPLATE	SCALE	NTS

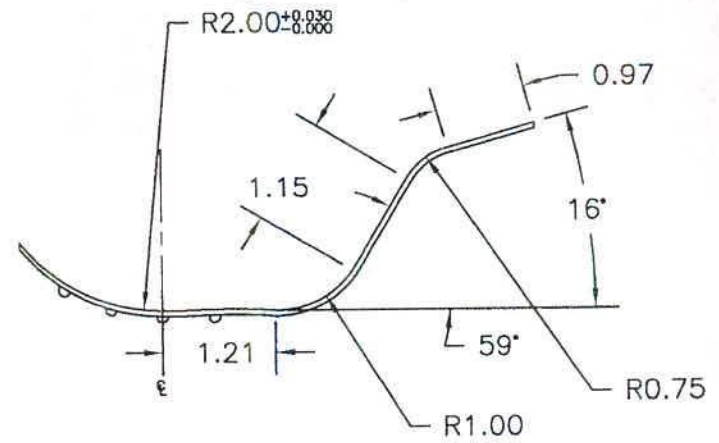
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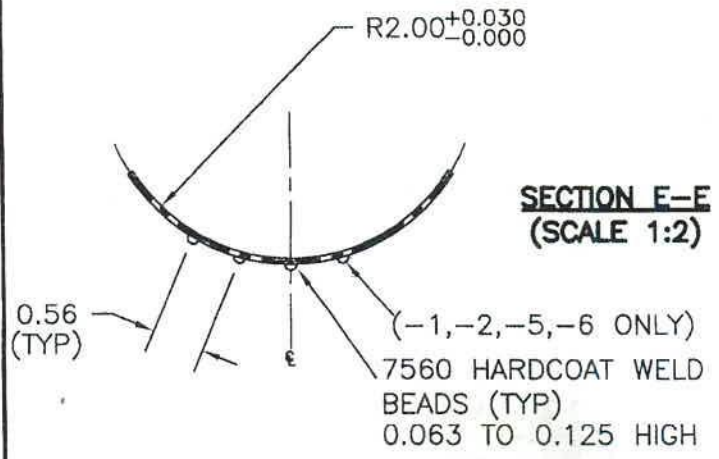
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DETAIL B
(SCALE 1:4)



SECTION F-F
(SCALE 1:2)



SECTION E-E
(SCALE 1:2)

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